
HJORTH DRILL GAGE

In shops where it is the practice to grind drills by hand, satisfactory results cannot be expected from the drill unless both of its lips are ground equally, so that each does its proper share of the work. Figs. 1 and 2 show two styles of

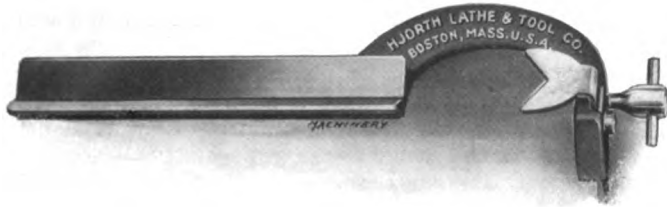


Fig. 1. Hjorth Gage for Drills up to 1 Inch in Diameter

gages which are made by the Hjorth Lathe & Tool Co., 27 School St., Boston, Mass., for testing the accuracy of a drill after it has been ground. The gage shown in Fig. 1 has a capacity for drills up to 1 inch in diameter, while the gage shown in Fig. 2 will take up to 2-inch drills.

It will be seen that the general arrangement of both gages is similar except that the larger one is provided with a stand.

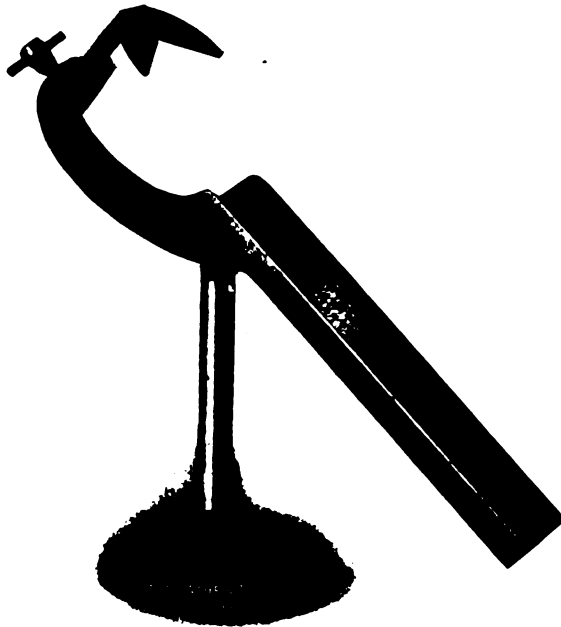


Fig. 2. Hjorth Gage for Drills up to 2 Inches in Diameter

Both gages have a V-slot in the handle in which the drill to be tested is laid. The gage proper has a 59-degree angle and may be adjusted vertically to bring it in line with the axis of different sizes of drills. In using such a gage, the drill is held firmly in place in the V-slot; the gage is next adjusted to bring it to the proper height; and the operator then observes whether the lips of the drill are parallel with the edges of the gage. If any discrepancy is found, further grinding must be resorted to until satisfactory results are obtained.
